

Work Order ID 115694

April-04-14 10:16:53 AM

\*115694\*

Page 1

Item ID: D3564-11

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Start Date: 4/04/14

Start Qty: 12.00

Required Date: 4/04/14

Req'd Qty: 12.00

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: MUS

Date: 14-04-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3564                          | Rev D                    |                      |         |        |              |               |               |                  |                |

100

\*100\*

Waterjet

FLOW CNC Waterjet

304-063"

FLOW WATER JET

Memo

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: 0 Prog  
Rev: 0 2-Debur if necessary

0.00

0.00

12

0

Jm 14-04-18

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

12

0

Jm 14-04-18

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

12

4/4/21



# Work Order ID 115694

April-04-14 10:16:53 AM

**\*115694\***

Page 2

Item ID: D3564-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Stainless Steel Wearplate Aft  
Start Date: 4/04/14 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 4/04/14 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool #            | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|-------------------|--------------|---------------|---------------|------------------|----------------|
| 130<br><b>*130*</b><br>Brake NC<br>Brake NC   | NC BRAKE<br><br>Memo<br>Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179        | 0.00<br><br>0.00     |         | DAS<br>30<br>9-89 |              | <u>12</u>     |               |                  | 14/04/30       |
| 140<br><b>*140*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo   | 0.00<br><br>0.00     |         |                   |              | <u>12</u>     |               |                  |                |
| 150<br><b>*150*</b><br>Large Fab<br>Large Fab | Large Fab<br><br>Memo<br>Qty Description Batch A/R<br><u>M127737</u> Weld hardcoat as per Dwg D3437 | 0.00<br><br>0.00     |         |                   |              | <u>4</u>      |               | <u>14-05-08</u>  | <u>MAL</u>     |





# Work Order ID 115694

April-04-14 10:16:53 AM

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Page 3

Item ID: D3564-11 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Stainless Steel Wearplate Aft

Start Date: 4/04/14 Start Qty: 12.00 \*12\* Cust Item ID:

Required Date: 4/04/14 Req'd Qty: 12.00 \*12\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160                            | QC10- Inspect visual per QSI004- ground welds | 0.00                 |         |        |              |               |               |                  |                |
| *160*                          |   |                      |         |        |              | ④             | 14-05-09      |                  | DAS 9 9-89     |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 170                            | QC5- Inspect part completeness to step on W/O | 0.00                 |         |        |              |               |               |                  |                |
| *170*                          |   |                      |         |        |              | ④             | 14-05-09      |                  | DAS 9 9-89     |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 180                            | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3      | 0.00                 |         |        |              |               |               |                  |                |
| *180*                          |   |                      |         |        |              | 4-④           | 14-5-9        |                  | DAS 34 9-89    |
| Powdercoat                     | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Powder Coating                 |   |                      |         |        |              |               |               |                  |                |
|                                | START TIME: 7:35                              |                      |         |        |              |               |               |                  |                |
|                                | FINISH TIME: 8:25                             |                      |         |        |              |               |               |                  |                |

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Work Order ID 115694

\*115694\*

Page 4

April-04-14 10:16:53 AM

Item ID: D3564-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Stainless Steel Wearplate Aft

Start Date: 4/04/14

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190                            | QC3- Inspect Part Finish                            | 0.00                 |         |        |              |               |               |                  |                |
| <b>*190*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              | 4x            | d             | ll               | 4/5/14         |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 200                            | Identify as per dwg & Stock Location: <u>FP-002</u> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*200*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              | x-1           | d             | ll               | 4/5/14         |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 210                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*210*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              | MCS           | 14-05-09      |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

MF  
14-5-9-





# Picklist Print

April-04-14 10:16:52 AM

Page 1

Work Order ID: 115694

**\*115694\***

Parent Item: D3564-11

**\*D3564-11\***

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
 IPP Rev:B As per Rev C 07-07-09 JLM  
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC  
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ  
 Verified By:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

197.7670

1.41

18

**\*M304S16GA\***

**\*\***

*7m14-04-18*

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

197.767

M126915

1.487

M127821

123.53

M128054

33.89

M128423

38.86

128423







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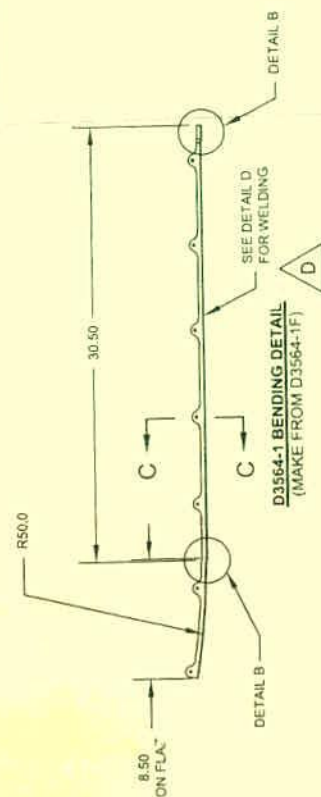
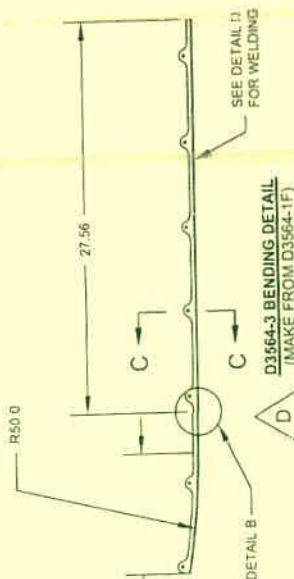
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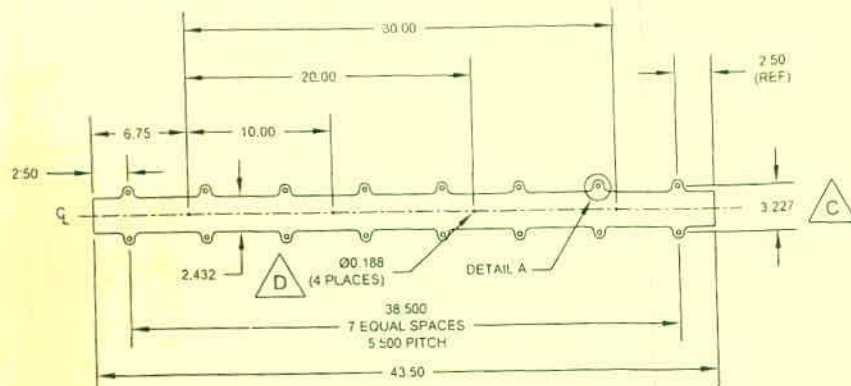
|   |                             |    |          |          |
|---|-----------------------------|----|----------|----------|
| UPDATE DRAWING TEMPLATE:<br>CHANGE ALL (TYP X TILS) TO (X PLACES);<br>PG1 AB: PG3 B5,C5: AMID D3564-15;<br>PG1 BE,B3: D3564-11;T WAS ONE FIGURE;<br>PG2 A7,A3: D3564-9-11 WAS ONE FIGURE;<br>PG2 A7,A3: D3564-9-11 WAS ON PG1;<br>PG3 BE,C8: D3564-13 WAS ON PG2;<br>PG3 D2: WELDING DETAIL WAS ON PG1<br>PG3 A5,7,B2: RELOCATE DETAILS AND SECTION;<br>PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE |                             | C8 |          | 07.08.21 |
| D   |                             |    |          |          |
| C   | MOVE TAB OUTBOARD, DETAIL A | PH | 07.04.17 |          |
| B   | ADD AMS 5513 AND AMS 5524   | PH | 07.03.20 |          |
| A   | NEW ISSUE                   | PH | 06.12.18 |          |
| REV   | DESCRIPTION                 | BY | DATE     |          |
| DESIGN  |                             |    |          |          |
| DRAWN   | PH                          |    |          |          |
| CHECKED   | CB                          |    |          |          |
| MFG APPR  | PH                          |    |          |          |
| APPROVED  | g                           |    |          |          |
| DE APPROV   | AP                          |    |          |          |
| DATE  | 07 08 21                    |    |          |          |

**WEIGHTS:**  
 O3584-1 195 lbs  
 O3564-3 195 lbs  
 O3564-5 193 lbs  
 O3564-7 126 lbs  
 O3584-9 135 lbs  
 O3564-11 135 lbs  
 O3564-13 138 lbs  
 O3564-15 190 lbs

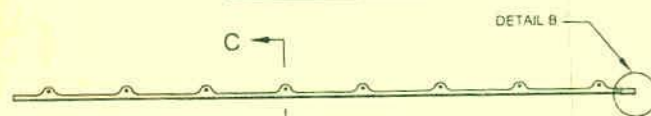
115694 465-  
1404-08



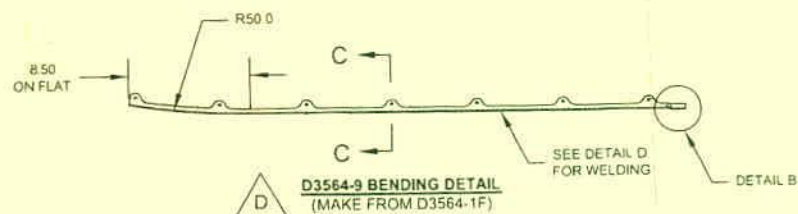




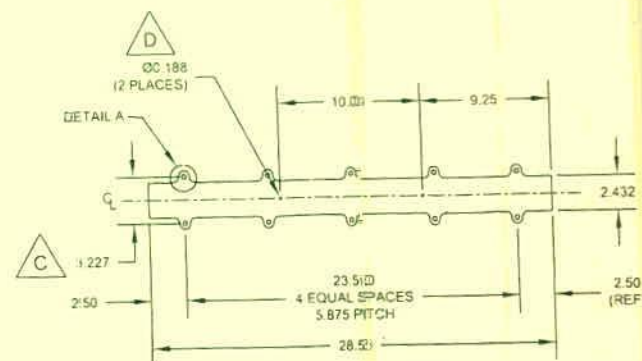
**D3564-5F FLAT PATTERN**



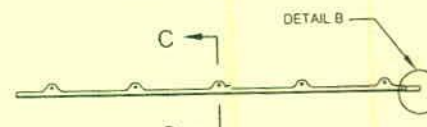
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



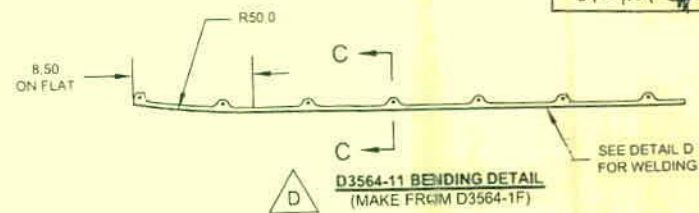
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



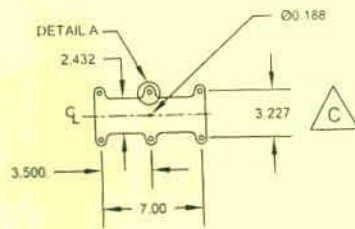
**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

UNDER REVIEW  
OK 11/17/28

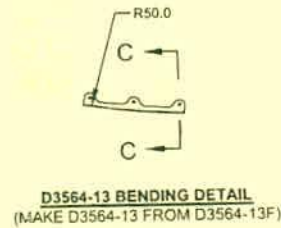
RELEASED  
07.09.04

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | CB       |  |              |
| CHECKED    | PH       | CRAWING NO.  | REV. D       |
| MFG. APPR. | PH       | D3564  | SHEET 2 OF 3 |
| APPROVED   | PH       | TITLE  | SCALE        |
| DE APPR.   | PH       | WEARSHOE   | 1:8          |
| DATE       | 07.08.21 | COPYRIGHT © 2008 BY DART AEROSPACE LTD.<br>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSES NOT AUTHORIZED BY THE DART AEROSPACE LTD. WITHOUT<br>THE WRITTEN PERMISSION OF DART AEROSPACE LTD. |              |

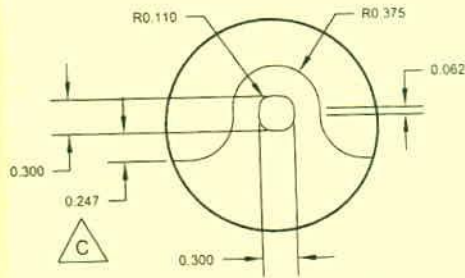




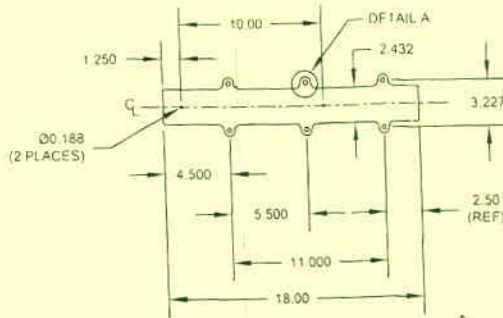
**D3564-13F FLAT PATTERN**



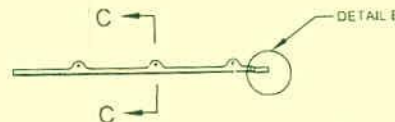
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



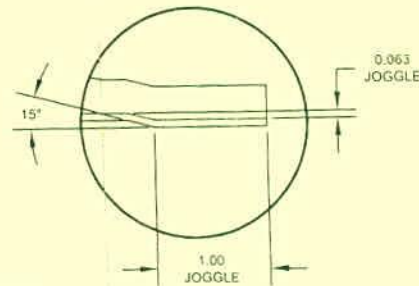
**DETAIL A**  
SCALE 1:1



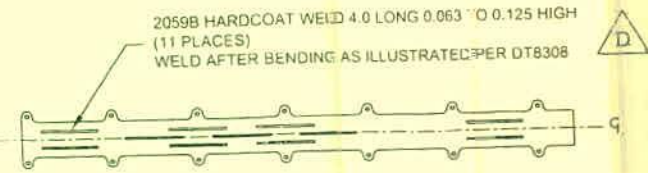
**D3564-15F FLAT PATTERN**



**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**DETAIL B**  
SCALE 1:1

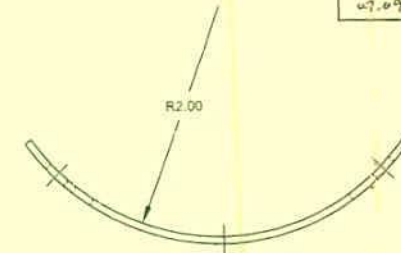


**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

2059B HARDCOAT WELD 4.0 LONG 0.063 "O 0.125 HIGH  
(11 PLACES)  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

**RELEASED**

07.09.04



**SECTION C-C**  
SCALE 1:1

**UNDER REVIEW**

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN      | CB       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED    | PH       | DRAWING NO.                            | REV. D       |
| MFG. APPR. | PH       | D3564                                  | SHEET 3 OF 3 |
| APPROVED   | PH       | TITLE                                  | SCALE        |
| DE APPR.   | PH       | WEARSHOE                               | 1:8          |
| DATE       | 07.08.21 | COPYRIGHT © 2008 BY DART AEROSPACE LTD |              |



